

Work Order ID 53513

November 6, 2009 4:10:08 PM



Page 1

Item ID: D3480-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Eyeball Inlet Adapter

Start Date: 06/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 17/11/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date:

06/11/09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3480

Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Spot weld as per dwg D3480 2-Cut tube flush as per dwg D3480 3-Deburr

=> m.d 04/12/18

4X

110

QC11- Inspect spot weld per QSI004

0.00



QC

Memo

0.00

Quality Control

SB 09/12/18

(4)

0

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> S 09/12/18

(44)

Work Order ID 53513

November 6, 2009 4:10:08 PM



Page 2

Item ID: D3480-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Eyeball Inlet Adapter

Start Date: 06/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 17/11/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

9/12/18 50 (40)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/18
Pl 09/12/18
(4)

Picklist Print

December 17, 2009 9:53:52 AM

Page 1

Work Order ID: 53513

Parent Item: D3480-041

Parent Item Name: Eyeball Inlet Adapter



Start Date: 12/7/2009

Required Date: 12/14/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3480-3 		Manufactured	No		B 54718-1		Each	0.0000	2.0000			
Tube												
D3480-5 		Manufactured	No				Each	4.0000	2.0000			
Eyeball Adapter Flange												

SB 09/12/17

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

42906

4

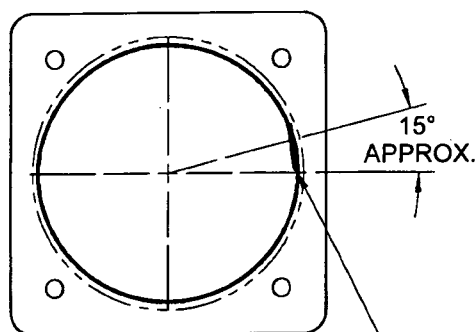
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4 SB 02/12/17

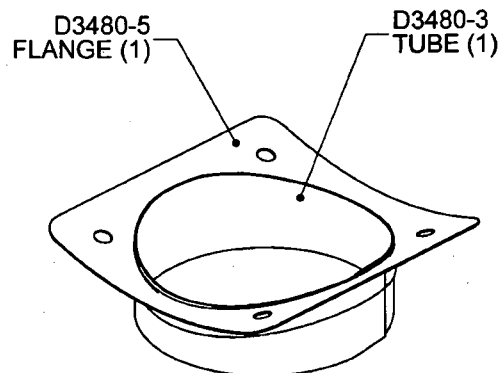


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3480	REV. C SHEET 1 OF 6
DATE 08.12.19		TITLE EYEBALL ADAPTER	SCALE 1:2
A	06.02.06	NEW ISSUE	
B	06.08.29	D3480-3 0.50 was 0.40/D3480-3F 8.930 was 9.330	
C	08.12.19	D3480-3 PICTORIAL CHG PER D3480-3F (SHT 1 & 4); ADD/REV TOL (SHT 3-5); ADD MFG NOTE (SHT 4); MATL SPEC WAS MIL-S-5019	

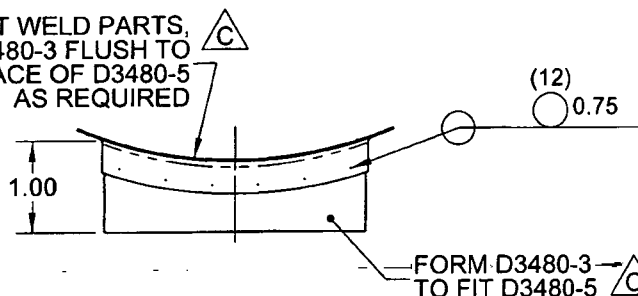
RELEASE
09/01/30 M/SV



ALIGN WELD
SEAM OF D3480-3
AS SHOWN



SPOT WELD PARTS,
TRIM D3480-3 FLUSH TO
SURFACE OF D3480-5
AS REQUIRED



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53513-
09-11-9

D3480-041 EYEBALL INLET ADAPTER

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

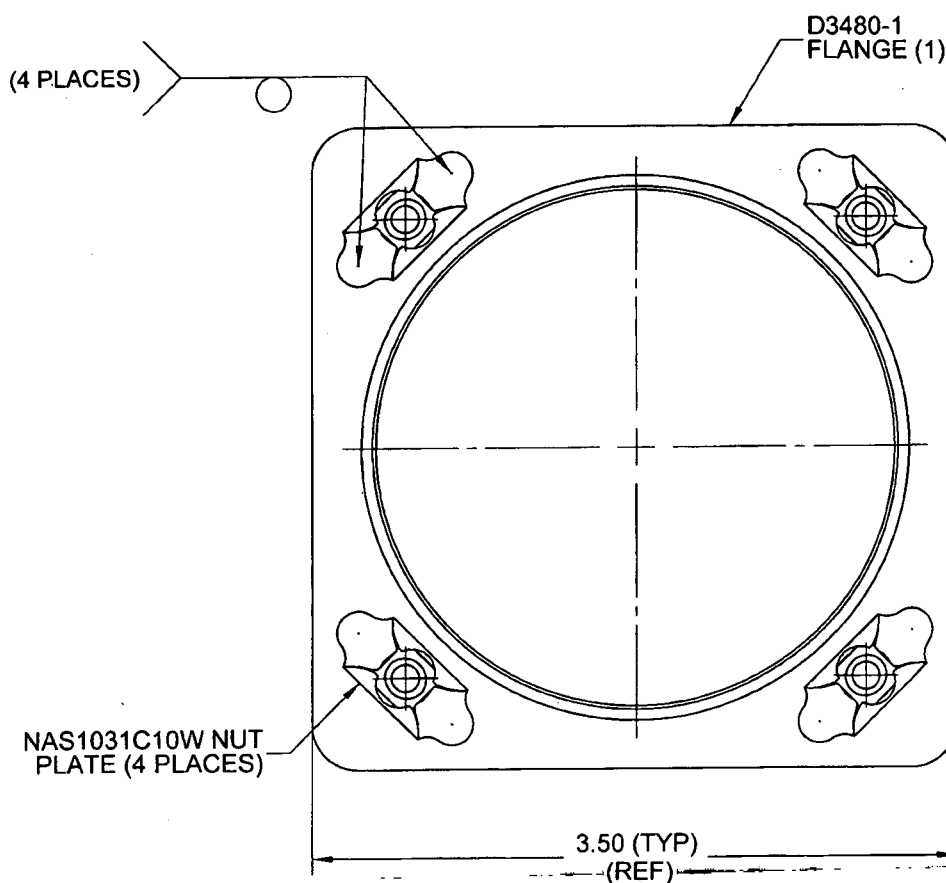
QTY -041	P/N	DESCRIPTION
X	D3480-041	EYEBALL INLET ADAPTER
1	D3480-3	TUBE
1	D3480-5	FLANGE

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DESIGN ✓	DRAWN BY ✓	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED P/L	APPROVED ✓	DRAWING NO. D3480	REV. C SHEET 2 OF 6
DATE 08.12.19		TITLE EYEBALL ADAPTER	SCALE 1:1

RELEASE
9/10/30 MBL**D3480-043 EYEBALL ADAPTER****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-043 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

w/ 53512

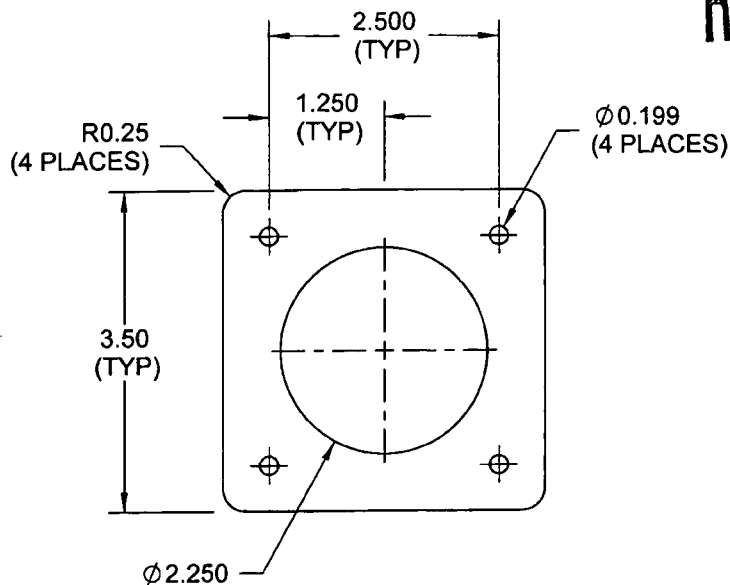
QTY -043	P/N	DESCRIPTION
X	D3480-043	EYEBALL ADAPTER
1	D3480-1	FLANGE
4	NAS1031C3W	NUTPLATE

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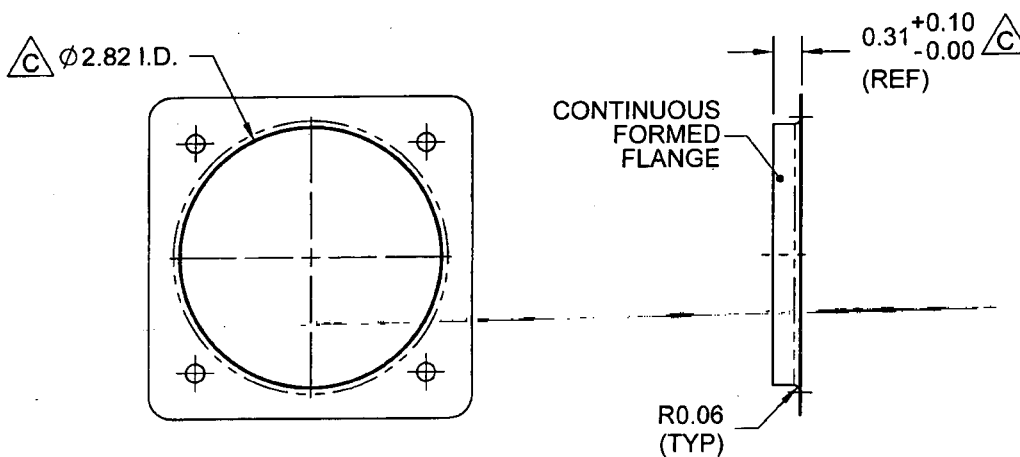
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CHECKED PH	APPROVED 1	DRAWING NO. D3480	REV. C SHEET 3 OF 6
DATE 08.12.19		TITLE EYEBALL ADAPTER	SCALE 1:2

RELEASED
9/6/13 MP

w/o 53513

D3480-1F FLAT PATTERN**D3480-1 FLANGE**
(MAKE FROM D3480-1F)**NOTES:**

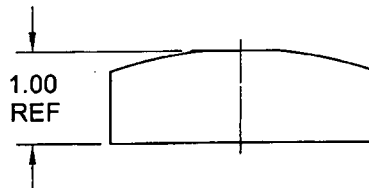
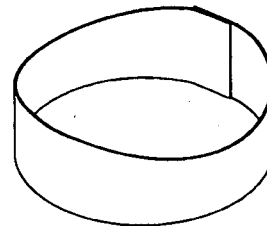
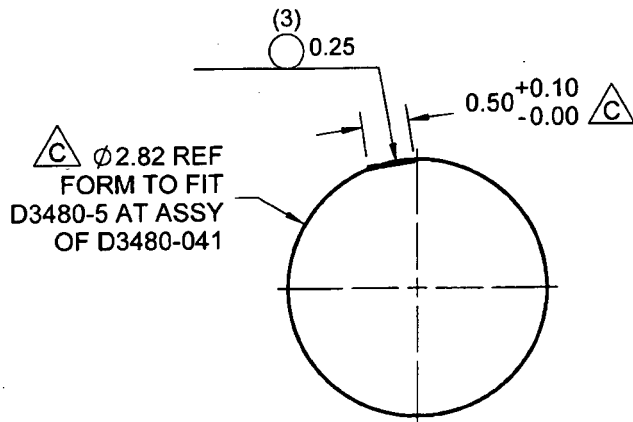
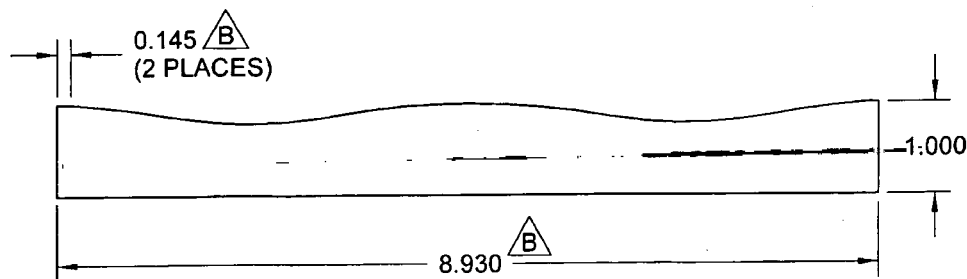
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle C$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 08.12.19	TITLE EYEBALL ADAPTER		SCALE 1:2

RELEASE
*09/01/30 M/D**w/o 53513***D3480-3 TUBE****D3480-3F TUBE FLAT PATTERN****NOTES:**

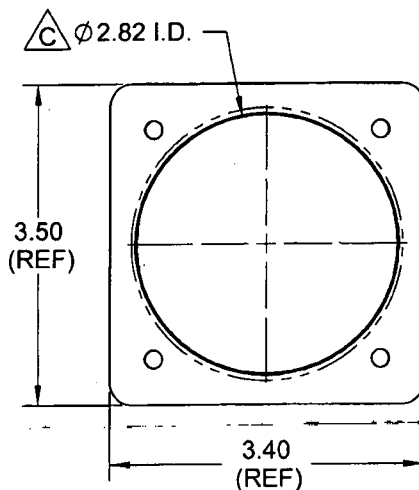
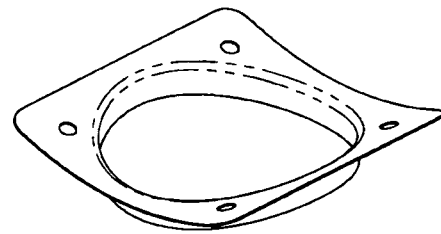
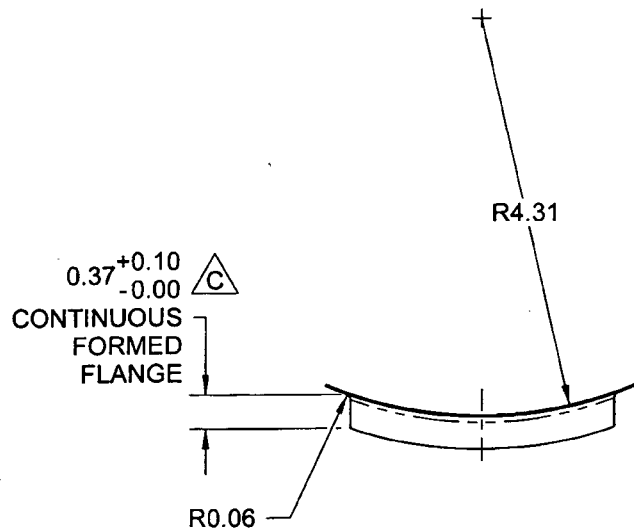
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle C$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3480	REV. C SHEET 5 OF 6
DATE 08.12.19		TITLE EYEBALL ADAPTER	SCALE 1:2

RELEASED
*09/01/20 MJD**W/0 53513***D3480-5 EYEBALL ADAPTER FLANGE****NOTES:**

- 1) MATERIAL: MAKE FROM D3480-1F
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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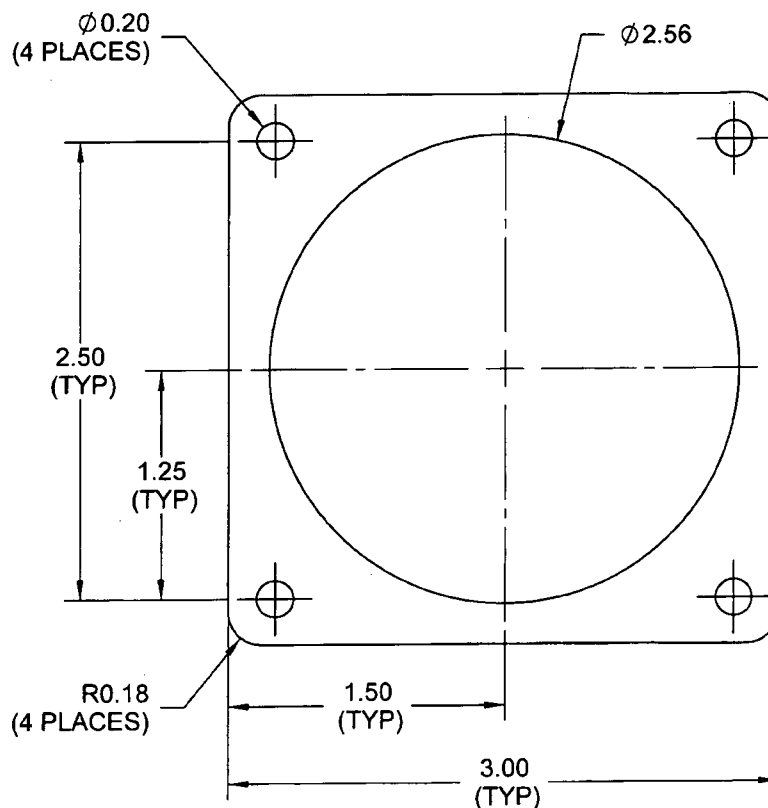
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3480	REV. C SHEET 6 OF 6
DATE 08.12.19		TITLE EYEBALL ADAPTER	SCALE 1:1

RELEASED
9/10/30 MP

W/O 53573



D3480-7 GASKET

NOTES:

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.125" THICK (REF. DART SPEC. M-SIL60-.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 73

EMPLOYEE: Marc Hegert

PART NUMBER: D 3480-041

JOB NUMBER: B 53513

MATERIAL TYPE: 304 L

MATERIAL THICKNESS: .018

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium SS

TEST RESULTS

	PASS	FAIL
VISUAL:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PENETRATION:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PULL STRENGTH:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 09/12/18

QUALIFIER: SB